

Date: Friday, 7/14/2006 12:01:34 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEM
 Job Number : 27924A
 Estimate Number : 10394
 P.O. Number : N/A
 This Issue : 7/14/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 26210A
 Part Number : D29681
 Drawing Number : D2968
 Project Number : N/A
 Drawing Revision : B1
 Material : N/A
 Due Date : 8/20/2006 Qty: 41 Um: Each
 Written By : SKY COMMENT BELOW
 Checked & Approved By : 06.07.14
 Comment : Est:C 03/04/11 Reformat; Incorporated D2968-1/-5 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NR0750 4130 steel rod .750"



Comment: Qty.: 0.4550 f(s)/Unit Total : 18.1986 f(s)

Material: AISI 4130 Ø 3/4 " Bar

(M4130N-R0.750)

Identify AS D2968-1

Batch: M19162 8.0f

M18767 3.5f

M8 06/07/28

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn Blank as per Folio FA047 and Dwg D2968

2-Deburr, no sharp edges

M8 06/07/28

41

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/08/02

41

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA047 and Dwg D2968

2- Deburr

J.F. 06/08/03

41

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/08/03

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/08/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 7/14/2006 12:01:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 27924A

Part Number: D29681

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.6 06/08/03 41

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 396

DO 6/8/3 (41)
RB 06/08/03 (41)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(41)
06/08/04

Job Completion



C 206/08/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27924A
Description: Stem		Part Number:	D2968-1
Inspection Dwg: D2968	Rev: B1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.040	+/-0.010	5.045				
4.020	+0.000/-0.010	4.025				
3.270	+/-0.010	3.275				
0.470	+/-0.010	.470				
0.250	+/-0.010	.248				
0.550	+/-0.010	.555				
Ø0.750	+/-0.010	.746				
Ø0.625	+/-0.010	.620				
Ø0.363	+/-0.010	.359				
0.250	+0.010/-0.000	.255				
0.625	+/-0.010	.623				
0.150	+/-0.010	.151"				
0.250	+0.010/-0.000	.250				
* 0.625	+/-0.010	.625				
0.150	+/-0.010	.147"				
1/4-28 Major dia	0.243 - 0.249	O.K 245				
MOW	0.261 - 0.267	O.K 265				

Measured by: MS/J.F	Audited by: B/S.G	Prototype Approval:	N/A
Date: 06/07/28	Date: 06/08/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D2968-041	KJ/RF	
B	05.05.26	Dimensions added	KJ/JLM	

